

GMK 2410

Rubber Metal Adhesive

Technical Datasheet

Create Date: 25.06.2013 - Page 1/1



A solvent-based Polychloroprene (CR) contact adhesive used for strong and flexible full-surface bonding of rubber to rubber and rubber to metal.

GMK 2410 also bonds cellular rubber (e. g. neoprene), leather, felt, insulating material, textiles, wood, and many plastics. After curing, the joint is resistant to humidity.

Technical data

Basis	Polychloroprene (CR)
Density	0,93 g/cm ³
Viscosity	about 2.400 mPa.s
Colour	yellowish-brown
Consumption	250 - 350 g/m ²
Evaporation time	5 - 10 min.
Contact adhesion time	10 min.
Final strength approx. after	about 24 h
Temperature range	-40 to +80, shortly up to +100 °C
Processing temperature	+15 to +35 °C
Average tensile shear strength	
Galvanised steel / EPDM	0,16 N/mm ²
Galvanised steel / galvanised steel	1,60 N/mm ²
Galvanised steel / SBR	0,54 N/mm ²
Galvanised steel / NBR	0,57 N/mm ²

Pretreatment of the surface

The parts to be bonded must be clean and dry and free of dust or grease (WEICON Surface Cleaner). Roughening the surfaces increases the bonding power efficiently.

Processing

Stir WEICON GMK 2410 carefully prior to use. Then apply the adhesive evenly and in a thin layer onto both surfaces using a brush or spatula (smooth or finely notched). Let it dry for 5 - 10 minutes depending on layer thickness, ambient temperature and air humidity. On absorbing surfaces (e. g. felt), a second adhesive layer should be applied when the first layer has dried.

As soon as the surfaces are dry but still a little bit tacky (finger test), the parts must be joined with a short but strong pressure. Once the evaporation time has passed, the adhesive must be applied again. Non-cured exceeding adhesive can be removed with WEICON Surface Cleaner.

Storage

At room temperature (+15°C to +25°C), dry, in densely closed packaging

Storage stability:

12 months in unopened container

Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

WEICON GmbH & Co. KG (Headquarter)

Königsberger Str. 255 · DE-48157 Münster
P.O. Box 84 60 · DE-48045 Münster
Germany

Tel. +49 (0) 251 / 93 22-0
Fax +49 (0) 251 / 93 22-244
Fax +49 (0) 251 / 93 22-233 Export
www.weicon.de · info@weicon.de

WEICON Middle East L.L.C.

Jebel Ali Ind Area 3 · P.O. Box 118 216
Dubai · U.A.E

Phone +971 4 880 25 05
Fax +971 4 880 25 09
Mobile +971 50 545 99 83
www.weicon.ae · info@weicon.ae

WEICON Inc.

20 Steckle Place · Unit 20
Kitchener · Ontario · N2E 2C3
Canada

Phone +1 519 896 5252
Fax +1 519 896 5254
Cell +1 519 590 5168
www.weicon.ca · info@weicon.ca

WEICON Kimya Sanayi Tic. Ltd. Şti.

Yenibosna Mahallesi Yalçın Koreş Caddesi
Arifağa Sokak No: 29 Kat: 3
34530 Yenibosna – İstanbul Turkey
www.weicon.biz.tr · info@weicon.biz.tr

WEICON Romania SRL

Str. Depozitelor 22
540240 Targu Mures, jud. Mures Romania
www.weicon.com · office@weicon.com